

Work Order ID 159706

Tuesday, April 18, 2017 9:11:56 AM

159706

Page 1

Item ID: D2739 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 350 I Beam
 Start Date: 4/18/2017 Start Qty: 14.00 ***14*** Cust Item ID:
 Required Date: 4/21/2017 Req'd Qty: 14.00 ***14*** Customer:
 Reference: SCHEDULED

Approvals: Process Plan: DAS 21 Date: APR 18 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-8 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2739	Rev E

100	Skid tubes	0.00							
100									
Skid tubes	Memo	6.15							
Skid tubes	1-Cut D2600-5 to length as per Dwg D2739.								
	2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739								
	3-Use uni-bit to open holes to finish size as per Dwg D2739.								
	4-Bevel Fwd end of extrusion and Deburr holes and ends.								
	5-Deburr								

14 MGB 17/04/19
 DT

120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	3.15							
Hand Finishing									

15 Q 17-04-27
 DT

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.28				14			EB 17-04-27
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>LG002</u> Memo LOCATION : LG002	0.00 0.14				14	Q	17-04-27	DT
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.40						17/5/1	DT

DAS
21
9-89

APR 27 2017

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WORK ORDER NON-CONFORMANCE / UPDATE

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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OTHER : _____					

Picklist Print

Tuesday, April 18, 2017 9:12:01 AM

Page 1

Work Order ID: 159706

159706

Parent Item: D2739

D2739

Parent Item Name: 350 I Beam

Start Date: 4/18/2017

Required Date: 4/21/2017

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP Rev: C02.11.28ReformatKJ
IPP Rev: D 06-03-21 As Per Rev C JLM
IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F
10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No			100	Each	211.0000	1	14			
D2600-5-108									**				
Extrusion 'I Beam' thin													

Location

Loc Qty

Loc Code

HALL

211

145248

211

M666

17/04/18

14

DQA: _____ Date: _____

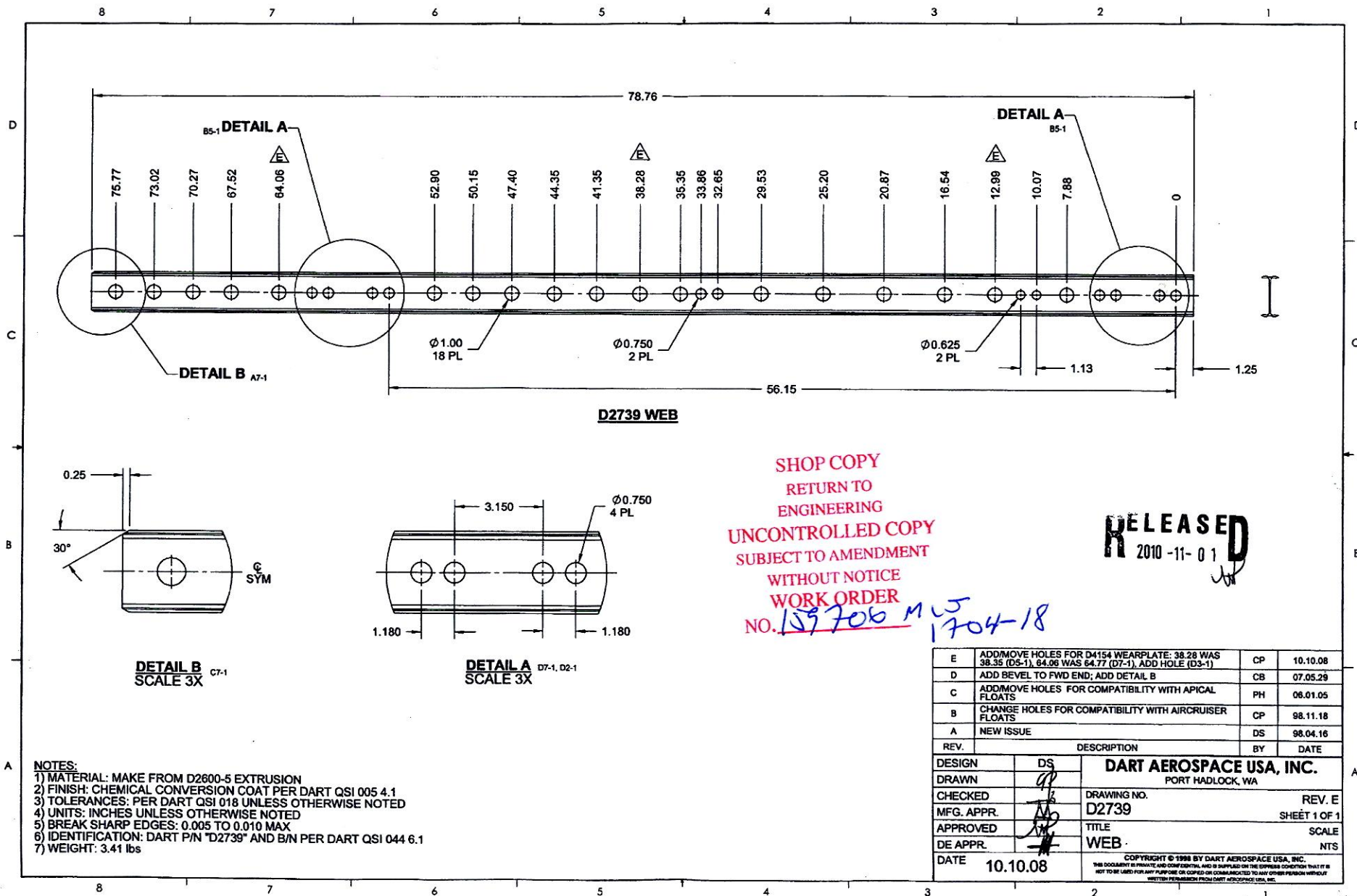


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Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
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